

Date: Wednesday, 1/31/2007 2:18:24 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 30545	
Estimate Number : 10256	
P.O. Number : <i>N/A</i>	Part Number : D22303
This Issue : 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2230 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 30273	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 2/7/2007
Checked & Approved By : <i>[Signature]</i> 07.01.31	Qty: <i>196</i> Um: <i>200</i> Each
Comment : Est D 00.95.18 Added inspection level 8, and removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0 f(s)/Unit Total : 14 f(s)
Lug Extrusion
D2423
Batch: *30062*

M8/J.F 07/01/31

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: Band Saw
Cut D2423 extrusion to 0.82"
Batch: *30062*

M8/J.F 07/01/31 196

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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RG



Issue P.O 3264



07/03/08 196

Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2230-3
Check for crack while loading into the machine.

Machine per draw D2230 Rev F

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RG



Review + inspect for transit damage



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/3/15 196

5.0	QC5	SECOND CHECK
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Comment: SECOND CHECK *Inspect level 5 0703.21 196*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 07/03/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:18:25 PM

User: - Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30545

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

N/A

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 07-03-21

(196)

8.0

QC3

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

U 07-03-21

9.0

POWDER COATING

POWDER COATING



M103706



(196x)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M-L 07/03/21

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

07/3/26 (196)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/3/26

07/03/25 196 SQ

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(196)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/27

Job Completion



U 07-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

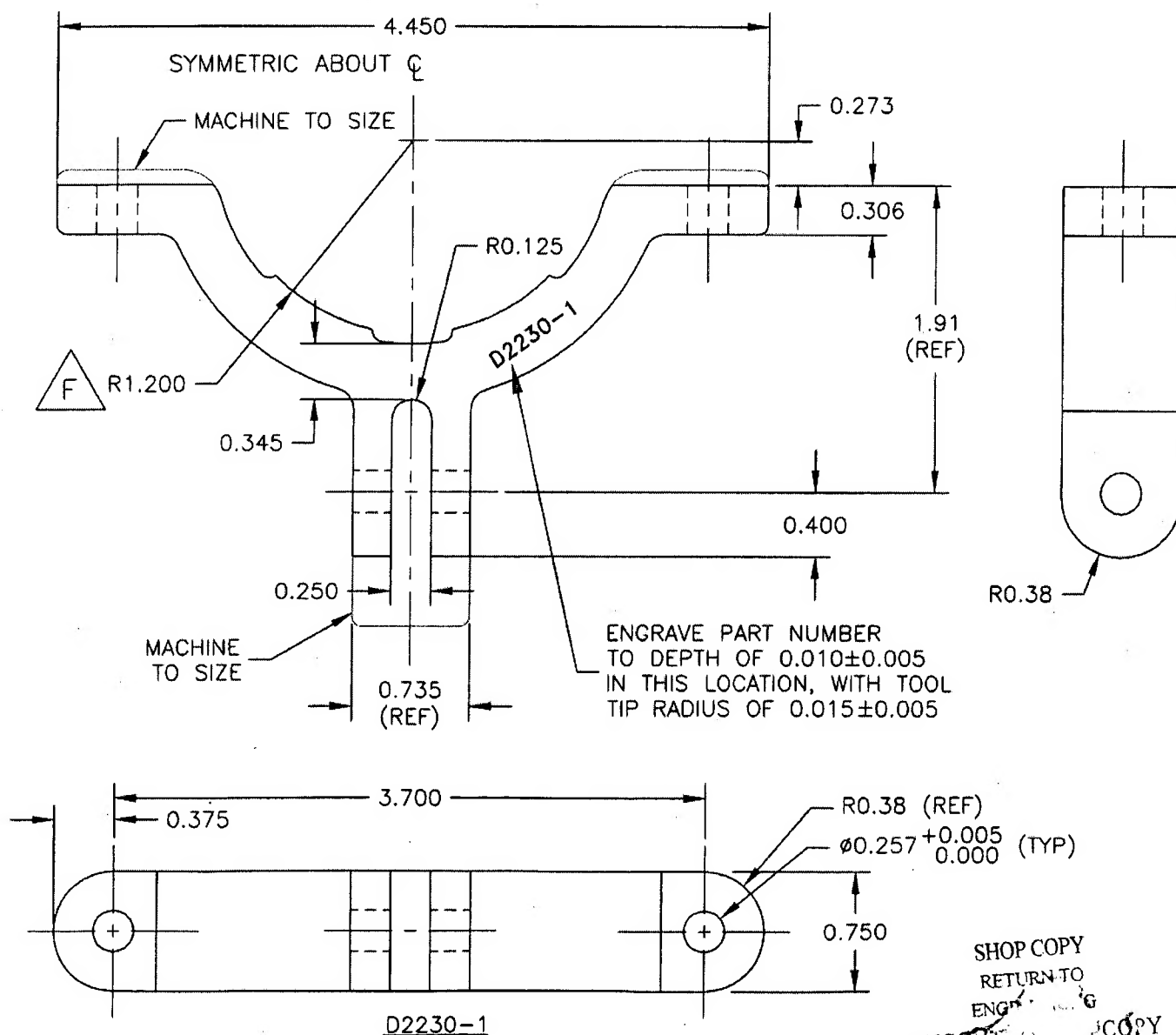
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

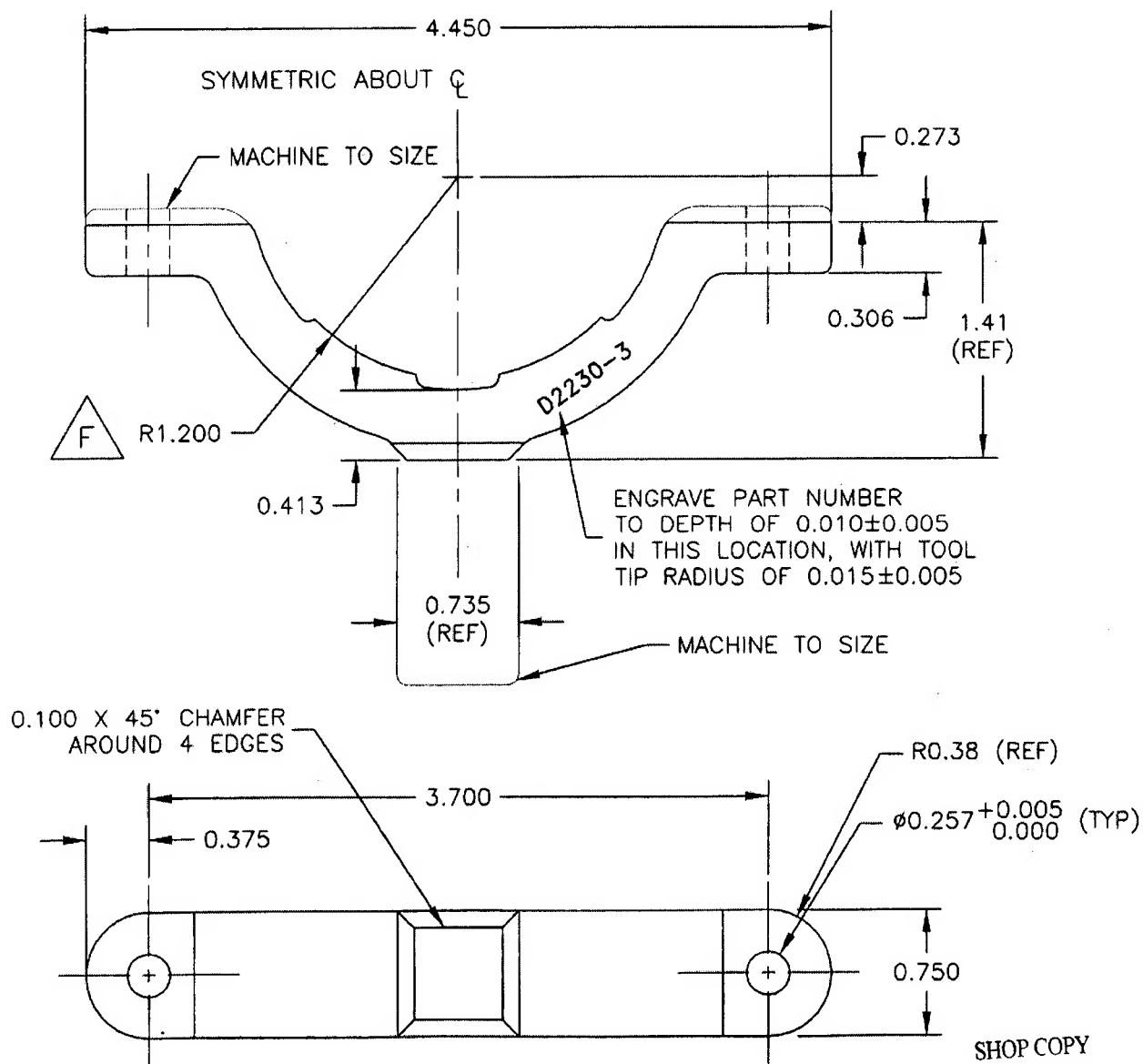
SHOP COPY
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UNCONTROLLED COPY
SUBMITTAL
E

NO. 30545



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
NOTICE
NO. 30545



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 15799
Date: Mar 19, 2007
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 3264 P/O	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Mar 19, 2007

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug B30545 ✓ Material supplied by DART #2423 B30062 ✓	Each		196	
Received by <u>Sonia Chiu</u>		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
196	D2230-3	Mounting Lug B30545	3264

MATERIAL: supplied by DART D2323 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Denise Robinson

Vankleek Hill, March 19, 2007

